

105623

Page 1

N900040100

Setup Start ***NS1***

Stop *NS2*

6

6

Reference:

Run Start *NR1*

Date:

Stop *NR2*

Date:

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 105623

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105623

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Item ID: D2894-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 2.750 SUPPORT

Start Date: 8/8/2013 Start Qty: 6.00

6

Cust Item ID:

Required Date: 9/19/2013 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>LG52</u>	0.00							
130									
Packaging	Memo	0.00				6	0	0	AL
Packaging									13-9-16
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

ML5 13-09-17

QB-09-17

Picklist Print

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Work Order ID: 105623

105623

Parent Item: D2894-1

D2894-1

Parent Item Name: 2.750 SUPPORT

Start Date: 8/8/2013

Required Date: 9/19/2013

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP: B02.11.26Added mask holeKJ

IPP Rev:C ECN 993 07-11-07 DD verified by:EC

IPP D 08.03.19 Re-format EC verified by DD IPP REV:E

11.10.03 ASPER REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK079		Manufactured	No			100	Each	5.0000	0.5	3			

DSK079

D2894-1 TURNING DETAIL

**

Location

Loc Qty

Loc Code

MAT060

5

94328

5

M105473 X 3 on 13/09/10

DART AEROSPACE LTD		Work Order:	105623
Description: Ø2.750 Support		Part Number:	D2894-1
Inspection Dwg: D2894	Rev: E	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
HAAS Section								
AA	0.454	0.474		.463	.463	.463	.463	.463
AB	3.062	3.082		3.072	3.072	3.072	3.072	3.072
AC	0.053	0.073		.063	.063	.063	.063	.063
AD	1.766	1.786		1.776	1.776	1.780	1.780	1.780
AE	0.020	0.040		.027	.030	.030	.030	.030
AF	0.260	0.267		.262	.262	.262	.262	.262
AG	0.170	0.190		.180	.180	.180	.180	.180
AH	0.150	0.170		.160	.160	.160	.160	.160
AI	1.970	2.030		1.995	1.996	1.997	1.997	1.997
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	1.880	1.900		1.893	1.893	1.892	1.894	1.895
AL	0.500	0.505		.5014	.5017	.5027	.5018	.502
AM	0.188	0.194		.189	.189	.189	.189	.189
Ensure that Ø0.500" bore is perpendicular to 1.389" bore within 0.003"								
Accept/Reject				.0025	.0005	.003	.0015	.0000

Measured by:	<i>CRK</i>	Date:	13/09/11
Audited by:	<i>JLM</i>	Date:	13.09.16
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	06.03.08	DT8708 added to dimension AM	KJ/JLM	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	08.04.22	Reformat; Dwg Rev updated	KJ/DD	
E	08.11.25	Dimensions updated per Dwg Rev. D	KJ/JLM	
F	09.05.04	Dimension AN (0.926) removed	Kj/JLM	
G	13.05.22	Dimensions updated per Dwg Rev. E	KJ	<i>[Signature]</i>

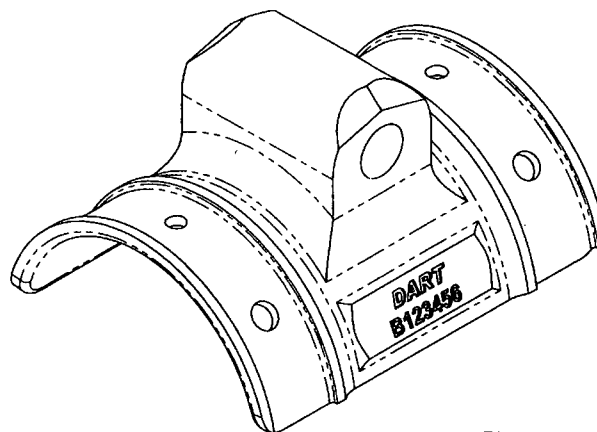
DART AEROSPACE LTD		Work Order:	1057023
Description: Ø2.750 Support		Part Number:	D2894-1
Inspection Dwg: D2894		Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				<i>16</i>	<i>2</i>	<i>3</i>	<i>4</i>	<i>5</i>
HAAS Section								
AA	0.454	0.474		.463				
AB	3.062	3.082		3.072				
AC	0.053	0.073		.063				
AD	1.766	1.786		1.778				
AE	0.020	0.040		.030				
AF	0.260	0.267		.262				
AG	0.170	0.190		.180				
AH	0.150	0.170		.160				
AI	1.970	2.030		1.997				
AJ	0.240	0.260		.250				
AK	1.880	1.900		1.889				
AL	0.500	0.505		.5019				
AM	0.188	0.194		.189				
Ensure that Ø0.500" bore is perpendicular to 1.389" bore within 0.003"								
Accept/Reject				.0025				

Measured by:	<i>[Signature]</i>	Date:	13/09/11
Audited by:	<i>[Signature]</i>	Date:	13-09-16
Preliminary Approval:		Date:	

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D2894-1 Ø2.750 SUPPORT

105623 MJS
11-08-08

RELEASED
2011-09-29

NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
PER ASTM A564 OR AMS 5643 OR AISI 630
MIN UTS = 170 KSI (38 HRC)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) 0.50" WIDE x 1.56" LONG x 0.005" MIN HEIGHT FLAT,
WITH R0.25 RADIUS OF TRANSITION IN THIS AREA
IDENTIFY WITH DART LOGO AND PART NUMBER ON ONE
SIDE AND DART LOGO AND BATCH NUMBER ON OPPOSITE
SIDE USING 0.010-0.020 DEEP LETTERING
- 7) WEIGHT: 0.98 lbs

E	REMOVE PRIMER & UPDATE MAT'L SPEC (ZN A8-1), 2.00 WAS 2.000 (C3-2), 4.00 WAS 4.000 (C6-2), REF. CAR 11-51	CP	11.09.07
D	DRAWING REFORMATTED, POWDER COAT FINISH REMOVED, CHAMFERS ADDED TO TOP OF PART TO CLEAR ROCKER BEAM, PER BELL TECH BULLETIN 407-08-84, B5-2 0.261 HOLE WAS 0.257, B2-2 REAM FINISH INSTRUCTION ADDED.	AJS	08.11.06
C	ADD MASKING AND PRIME ONLY NOTES, REFORMATTED DRAWING.	DC	07.07.04
B	AS MANUFACTURED	CP	02.07.17
A	NEW ISSUE	CP	02.04.02
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED	AS	DRAWING NO.	REV. E
MFG. APPR.	AS	D2894	SHEET 1 OF 2
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	Ø2.750 SUPPORT	NTS
DATE	11.09.07	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

